

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019899**Date Inspected:** 15-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Guo Hui. AB Fluor QA identified as Yu Jias.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3019L-1

Weld No: 107

Welder: 037723

WPS-B-P-2232-ESAB

Components; OBG 13AE

PCMK: SEG3007AY

Weld No: 050

Welder: 066733

WPS-B-T-2232-ESAB

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Components; OBG 14E
PCMK: SEG3019AG
Weld No: 001
Welder: 066763
WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Guo Hui. AB Fluor QA identified as Yu Jias.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E
PCMK: SA3019J
Weld No: 261
Welder: 067571
WPS-B-T-2214-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3019G
Weld No: 089
Welder: 0067571
WPS-B-T-2214-TC-U4b-FCM-1

Bay 13

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Guo Hui. AB Fluor QA identified as Yu Jias
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; Grillage Plate
PCMK: SA7038C
Weld No: 223,228,231,262,
Welders: 216086
WPS-345-SMAW-1G(1F)-FCM-Repair

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Submerged Arc Welding (SAW) process.
ZPMC QC is identified as Wang Xiang Ping. AB Fluor QA identified as Ji Cai Jamg (Jim).
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

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Components; OBG DP3136 to DP3135A (see photo below)

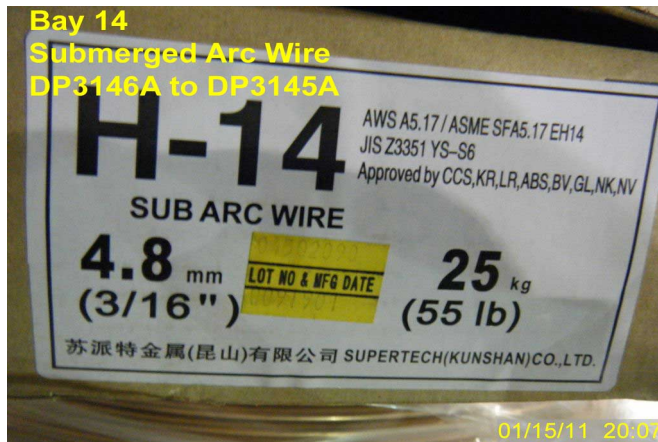
PCMK: SEG3014

Weld No: 003

Welders: 250050

WPS-B-T-2221-B-L2C-S-2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer